

Work Order ID 158606

158606

Page 1

Tuesday, March 28, 2017 10:20:10 AM

Item ID: D066-1001-013 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R66 Bearpaws with Wearplates - Large
Start Date: 3/28/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/7/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: **DAS 21 9-89** Date: **MAR 28 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	MAR 28 2017	DAS	6					
IIN-D066-1001	REV B	9-89							

100 Document Control 0.00
100 DOCUMENT CONTROL **2 DAS 27 9-89**
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPD066-1001-013 CHG 003

APR 18 2017

110 Pick Kit 0.00
110 Packaging Memo 0.00
Packaging

2 MAR 29 2017 DAS 6 9-89 DAS 28 9-89

120 QC4- 100% Inspect kits for completeness 0.00
120 QC Memo 0.06
Quality Control

2 DAS 27 9-89

APR 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 158606***158606***

Page 2

Tuesday, March 28, 2017 10:20:10 AM

Item ID: D066-1001-013 Accept ***N900040100*** Setup Start ***NS1***
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Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1001-013								
	Location: _____								
	PPP Rev: _____ fs 013								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

X2 **DAS 27 9-89**
APR 18 2017

DAS 21 9-89
APR 18 2017

DAS 21 9-89
APR 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, March 28, 2017 10:20:13 AM

Page 1

Work Order ID: 158606

158606

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM IPP REV:C
15.04.08 AS PER CHG003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3456-1

Manufactured

No

110

Each

95.0000

4

8

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

38

152842

13

154870

25

ST038A

50

157166

50

D3556-1

Manufactured

No

110

Each

24.0000

4

8

D3556-1

R44 Bearpaw Clamp

**

Location

Loc Qty

Loc Code

ST542

24

152480

24

D3601-1

Manufactured

No

110

Each

350.0000

8

16

D3601-1

Radius Block

**

Location

Loc Qty

Loc Code

ST045

350

155087

145

156511

205

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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158606

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

D4930-3

Manufactured No

110

Each

5.0000

2

4

D4930-3

Bearpaw

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST454a

5

112356

1

156379

4

D4952-041

Manufactured No

110

Each

6.0000

4

8

D4952-041

Wearplate Assembly

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST188

6

149636

6

D4953-1

Manufactured No

110

Each

116.0000

4

8

D4953-1

Cushion

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

st543

116

153229

116

AN4-12A

Purchased No

110

Each

136.0000

4

8

AN4-12A

Bolt

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

126

m135704

6

m136579

120

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
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Page 3

Work Order ID: 158606

158606

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

AN4-15A Purchased No

110 Each 177.0000 4 8

AN4-15A

Bolt

**

MAR 29 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 10
120449 10
ST343 167
m135859 167

DAS
27
9-89

AN4-16A Purchased No

110 Each 173.0000 4 8

AN4-16A

Bolt

**

MAR 29 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG 5
121541 5
over003 100
M136986 100
ST343 68
M136740 68

DAS
27
9-89

NAS1149D0463J Purchased No

110 Each 1,923.000 8 16

NAS1149D0463.J

Washer

**

MAR 29 2017

DAS
28
9-89
DAS
6
9-89

Location

Loc Qty

Loc Code

GA 67
M134508 13
M135056 54
ST263 1856
M136838 856
M136983 1000

DAS
27
9-89

16

Tuesday, March 28, 2017 10:20:13 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER : _____					

Picklist Print

Tuesday, March 28, 2017 10:20:13 AM

Page 4

Work Order ID: 158606

158606

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

1,261.000

12

24

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

172

m135058

172

OVER007

500

m136986

500

ST303

579

m136450

500

m136838

79

DAS
27
9-89

DAS
28
9-89
MAR 29 2017

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

REFERENCE ONLY

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
<i>Bearpaw Installation (Small)</i>	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
<i>Bearpaw Installation (Large)</i>	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: B

Date: 13.11.13

Work Order ID 158606

Tuesday, March 28, 2017 10:20:10 AM

158606

Page 1

Item ID: D066-1001-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 3/28/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/7/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED

Approvals: Process Plan: DASDate: MAR 28 2017

Tooling: _____

Date: _____

Run Start

NR1QC: 21

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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MAR 28 2017

Draw Nbr	Revision Nbr
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IIN-D066-1001	REV B
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100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-013		CHG 003						

2 **DAS**
27
9-89APR 18 2017

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

2MAR 29 2017**DAS**
6
9-89 **DAS**
28
9-89

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

2 **DAS**
27
9-89APR 18 2017